

[illegible]

1. An injection moulding process for the injection into a mould of a single-phase solution of polymer and propellant which is prepared in a plasticising cylinder of an injection moulding machine, characterised in that upon opening of a guard device of the injection moulding machine by the person operating the machine the connection between the plasticising cylinder and the mould is interrupted and the maximum speed of displacement of the screw arranged in the plasticising cylinder is limited.
2. An injection moulding process according to claim 1, characterised in that the force acting on the screw is reduced to such a degree that the pressure level in the plasticising cylinder is just sufficient to keep the single-phase solution of polymer and propellant gas prepared therein in the single-phase condition.
3. An injection moulding process according to claim 2, characterised in that a mass pressure of between about 100 and 300 bars is maintained in the plasticising cylinder.
4. An injection moulding process according to claim 1, characterised in that the speed of the screw is reduced to less than $1/10$, preferably to less than $1/20$, of the usual maximum speed in the injection operation.
5. An injection moulding process according to claim 1, characterised in that the maximum speed of the screw is reduced to zero if an end position monitoring means does not signal the interruption in the connection between the plasticising cylinder and the mould.
6. An injection assembly for an injection moulding machine, in particular for carrying out the process according to claim 1,

comprising a screw mounted in a plasticising cylinder and an injection piston which moves the screw in the longitudinal direction and which is mounted in an injection cylinder, wherein there is provided a supply conduit for the injection cylinder having a control valve which can be shut off, characterised in that there is provided an additional conduit (14) which by-passes the control valve (13) and in which are arranged a device (17) for reducing the amount of the pressure fluid flowing to the injection cylinder (7) and possibly a device (16) for reducing the pressure.

7. An injection assembly according to claim 6, characterised in that the device for reducing the pressure of the feed flow of pressure fluid is a pressure-reducing valve (16).

8. An injection assembly according to claim 6, characterised in that the device for reducing the amount of the feed flow of pressure fluid is a throttle (17).

9. An injection assembly according to claim 6, characterised in that a control valve (15) which can be shut off is further provided in the additional conduit (14).

10. Apparatus for carrying out the process according to claim 1, characterised in that an electric motor (20) whose rotary speed is variable is provided for driving the screw.

11. Apparatus according to claim 10, characterised in that the torque of the electric motor (20) is variable.

12. An injection assembly according to claim 6, characterised in that the plasticising cylinder (1) is provided with a preferably hydraulically actuated closure nozzle (5) with at least one end

13. An Injection assembly according to claim 6, characterised in that provided in the plasticising cylinder (1) is at least one pressure sensor (4) for monitoring the pressure in the plasticising cylinder (1).

1. $\frac{1}{2}$ lb. butter
 2. $\frac{1}{2}$ lb. sugar
 3. $\frac{1}{2}$ lb. flour
 4. $\frac{1}{2}$ lb. eggs
 5. $\frac{1}{2}$ lb. milk
 6. $\frac{1}{2}$ lb. cream
 7. $\frac{1}{2}$ lb. vanilla
 8. $\frac{1}{2}$ lb. salt
 9. $\frac{1}{2}$ lb. yeast
 10. $\frac{1}{2}$ lb. hops
 11. $\frac{1}{2}$ lb. malt
 12. $\frac{1}{2}$ lb. water
 13. $\frac{1}{2}$ lb. fire
 14. $\frac{1}{2}$ lb. iron
 15. $\frac{1}{2}$ lb. steel
 16. $\frac{1}{2}$ lb. copper
 17. $\frac{1}{2}$ lb. brass
 18. $\frac{1}{2}$ lb. tin
 19. $\frac{1}{2}$ lb. lead
 20. $\frac{1}{2}$ lb. zinc
 21. $\frac{1}{2}$ lb. silver
 22. $\frac{1}{2}$ lb. gold
 23. $\frac{1}{2}$ lb. platinum
 24. $\frac{1}{2}$ lb. mercury
 25. $\frac{1}{2}$ lb. arsenic
 26. $\frac{1}{2}$ lb. antimony
 27. $\frac{1}{2}$ lb. bismuth
 28. $\frac{1}{2}$ lb. cadmium
 29. $\frac{1}{2}$ lb. cobalt
 30. $\frac{1}{2}$ lb. nickel
 31. $\frac{1}{2}$ lb. manganese
 32. $\frac{1}{2}$ lb. iron
 33. $\frac{1}{2}$ lb. steel
 34. $\frac{1}{2}$ lb. copper
 35. $\frac{1}{2}$ lb. brass
 36. $\frac{1}{2}$ lb. tin
 37. $\frac{1}{2}$ lb. lead
 38. $\frac{1}{2}$ lb. zinc
 39. $\frac{1}{2}$ lb. silver
 40. $\frac{1}{2}$ lb. gold
 41. $\frac{1}{2}$ lb. platinum
 42. $\frac{1}{2}$ lb. mercury
 43. $\frac{1}{2}$ lb. arsenic
 44. $\frac{1}{2}$ lb. antimony
 45. $\frac{1}{2}$ lb. bismuth
 46. $\frac{1}{2}$ lb. cadmium
 47. $\frac{1}{2}$ lb. cobalt
 48. $\frac{1}{2}$ lb. nickel
 49. $\frac{1}{2}$ lb. manganese
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 51. $\frac{1}{2}$ lb. steel
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 56. $\frac{1}{2}$ lb. zinc
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 58. $\frac{1}{2}$ lb. gold
 59. $\frac{1}{2}$ lb. platinum
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 64. $\frac{1}{2}$ lb. cadmium
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 69. $\frac{1}{2}$ lb. steel
 70. $\frac{1}{2}$ lb. copper
 71. $\frac{1}{2}$ lb. brass
 72. $\frac{1}{2}$ lb. tin
 73. $\frac{1}{2}$ lb. lead
 74. $\frac{1}{2}$ lb. zinc
 75. $\frac{1}{2}$ lb. silver
 76. $\frac{1}{2}$ lb. gold
 77. $\frac{1}{2}$ lb. platinum
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 79. $\frac{1}{2}$ lb. arsenic
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 106. $\frac{1}{2}$ lb. copper
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 113. $\frac{1}{2}$ lb. platinum
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 126. $\frac{1}{2}$ lb. tin
 127. $\frac{1}{2}$ lb. lead
 128. $\frac{1}{2}$ lb. zinc
 129. $\frac{1}{2}$ lb. silver
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 142. $\frac{1}{2}$ lb. copper
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 144. $\frac{1}{2}$ lb. tin
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 146. $\frac{1}{2}$ lb. zinc
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 148. $\frac{1}{2}$ lb. gold
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 176. $\frac{1}{2}$ lb. iron
 177. $\frac{1}{2}$ lb. steel
 178. $\frac{1}{2}$ lb. copper
 179. $\frac{1}{2}$ lb. brass
 180. $\frac{1}{2}$ lb. tin
 181. <